

Date: Friday, 04/01/2008 7:46:59 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	36561		
Estimate Number :	11181		
P.O. Number :	N/A	Part Number :	D32941
This Issue :	04/01/2008	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3294 REV A1
First Issue :	N/A	Project Number :	N/A
Previous Run :	35134	Drawing Revision :	A1
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	11/01/2008
Written By :			
Checked & Approved By :			
Comment :	Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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29.5008



Comment: Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080)
Identify for D3294-1
Batch: 105411 HB 8-1-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3294
Dwg Rev: A1
Prog Rev: A1

HB 8-1-4

14

2-Deburr if necessary HB 8-1-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-1-4



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/01/07 14

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

Done at step 2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 08/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/01/2008 7:46:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 36561

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3294

SB 08/04/07

(14)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/01/07

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

08/01/08

(14X)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 100 700

BR 08-01-08

(14X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

M-L

08/01/08

(14X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST211

8/1/9

SD

(14X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/09

(14)

Job Completion



U 08-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



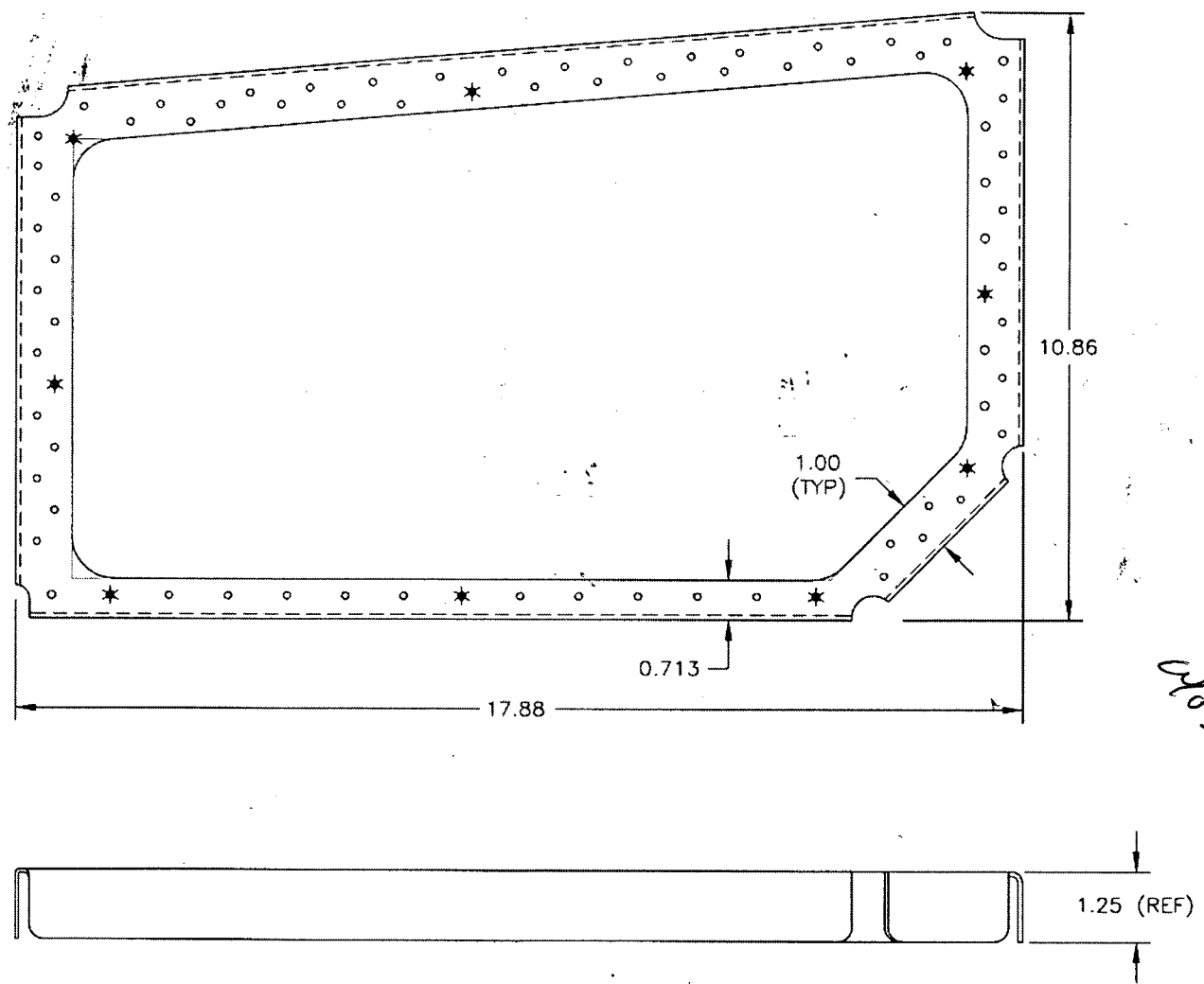
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	40	DRAWN BY	40	REV. A	
CHECKED	40	APPROVED	40	DRAWING NO.	SHEET 1 OF 2
DATE	04.06.28	TITLE	BRACKET	SCALE	1:3

A	04.06.28	NEW ISSUE
A1	05.06.13	12.47 WAS 13.03, AS MANUFACTURED

RELEASED
04 07 12

- D3294-1 BRACKET
- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
 - 2) CHECK PER TEMPLATE D3294-1T1
 - 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
 - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
 - 5) USE MINIMUM BEND RADIUS OF 0.188"
 - 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

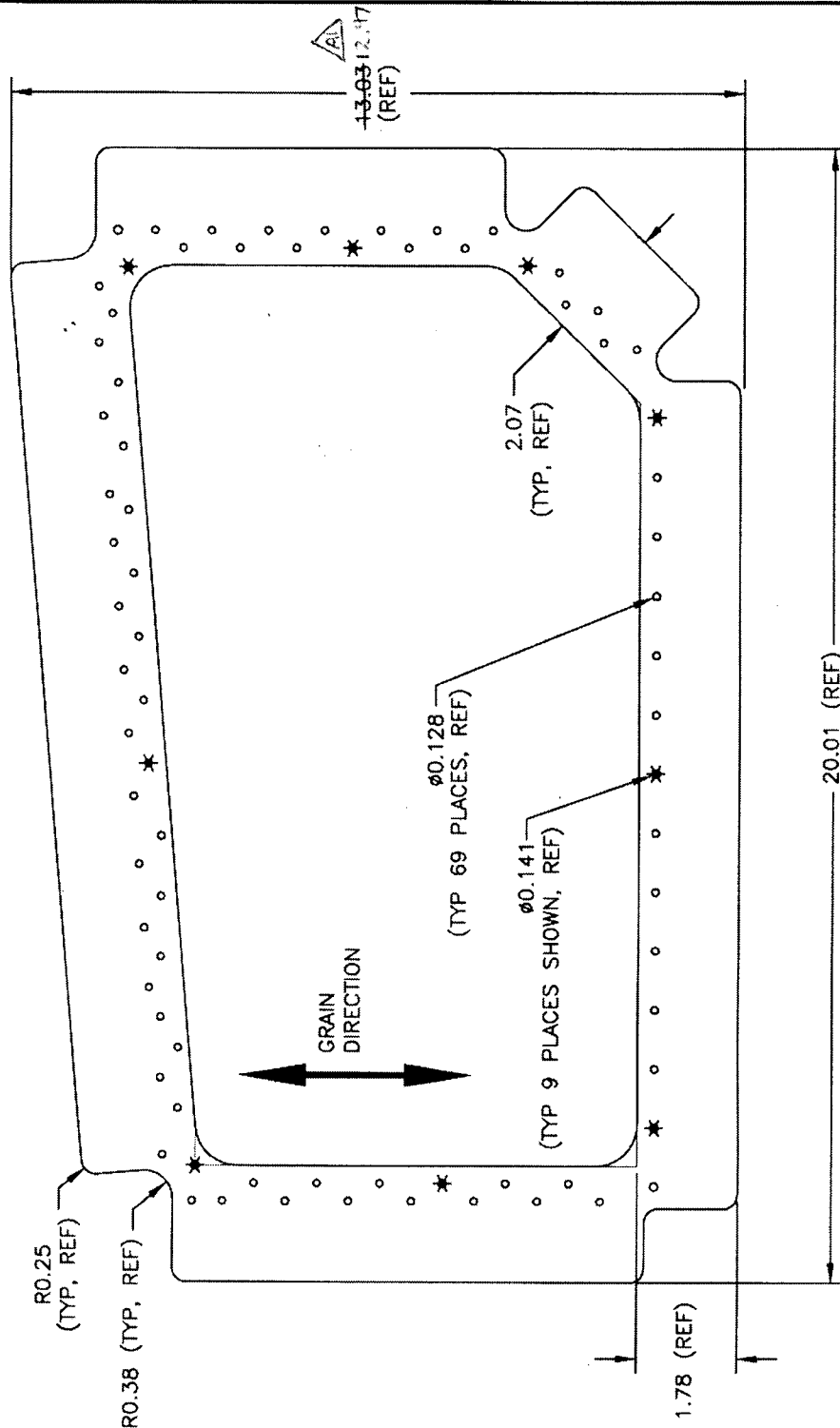




DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3294	REV. A SHEET 2 OF 2
DATE 04.06.28		TITLE BRACKET	SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED
04 07 12



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